



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2281
Job Sheet 176348



Part No: D2281

Job Qty: 50 ea

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/20/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		5/11/18	0.00	0.00	Start Up Waterjet		ac 18/05/02
100	Waterjet	50 pcs		5/11/18	0.00	2.62	Waterjet1		ac 18/05/02
120	QC	50 pcs		5/11/18	0.00	0.00	QC8		38
140	Brake NC	50 pcs		5/11/18	0.01	1.26	Brake NC 1		38 SB DAS
150	QC	50 pcs		5/11/18	0.00	0.00	QC5		38
160	Packaging	50 pcs		5/11/18	0.00	0.00	Packaging3		9-88
170	QC21-SA	50 Ea		5/11/18	0.00	0.00	QC21		21 MAY 16 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: G Prog Rev: G 2-Deburr if necessary

Descriptions: 140 - Form as per D2281 using D2281-T2

160 - LOCATION : WA001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	6.2500 sf (.125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	6	21	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches $\pm$ 0.010	4.478 4.458		
2	Jack Saddle	4.114Inches $\pm$ 0.010	4.124 4.104		
3	Jack Saddle	2.933Inches $\pm$ 0.010	2.943 2.923		
4	Jack Saddle	1.535Inches $\pm$ 0.010	1.545 1.525		
5	Jack Saddle	0.354Inches $\pm$ 0.010	0.364 0.344		
6	Jack Saddle	0.354Inches $\pm$ 0.010	0.364 0.344		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																												
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Date : _____	Sten #: _____	Dart Aerospace Ltd. 1270 Aberdeen Street Windsor, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 05/02/18 Container No: S067910 Part: D2281 Job No: 176348 Serial No/Batch: S067910 Revision: _____ Inspector: _____																																														
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7	Jack Saddle	0.604Inches ± 0.010	0.614 0.594	
8	Jack Saddle	2.000Inches ± 0.010	2.010 1.990	
9	Jack Saddle	3.396Inches ± 0.010	3.406 3.386	
10	Jack Saddle	3.646Inches ± 0.010	3.656 3.636	
11	Jack Saddle	4.000Inches ± 0.010	4.010 3.990	
12	Jack Saddle	1.525Inches ± 0.010	1.535 1.515	
13	Jack Saddle	2.475Inches ± 0.010	2.485 2.465	
14	Jack Saddle	0.323Inches $+ 0.006$ $- 0.001$	0.329 0.322	Diameter
15	Jack Saddle	0.080Inches ± 0.010	0.090 0.070	

Plex 5/1/18 8:27 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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